

Date: Thursday, 8/24/2006 11:11:40 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING
 Job Number : 28333
 Estimate Number : 10858
 P.O. Number : *N/A*
 This Issue : 8/24/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 26517
 Part Number : D34075
 Drawing Number : D3407 REV C
 Project Number : N/A
 Drawing-Revision : C
 Material : *N/A*
 Due Date : 9/20/2006 Qty: 10 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 06.08.24
 Comment : Est Rev:A New Issue 05-11-22 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174R3000 Inventory



Comment: Qty.: 0.0306 f(s)/Unit Total: 0.3056 f(s)
 Material: 17-4ph SS Round Bar Ø3.000(M17-4-R3.000)
 Identify for D3407-5
 Batch: *18742*

J.G

06/09/07

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per Folio FA598 Rev: _____ & Dwg D3407 Rev: _____

2-Deburr

Receive & Inspect for transd change

06/09/20 (22)

3.0 QC8 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/09/20 (22)

06/09/20 (22)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

N/A

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57434*

06/09/21 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/09/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 8/24/2006 11:11:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 28333

Part Number: D34075

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

W 06/09/21

Job Completion



W 06/09/21

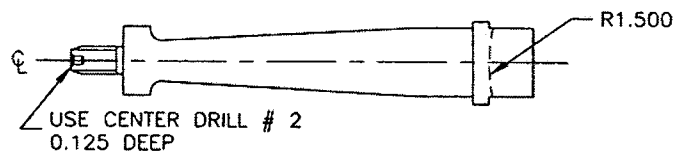
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

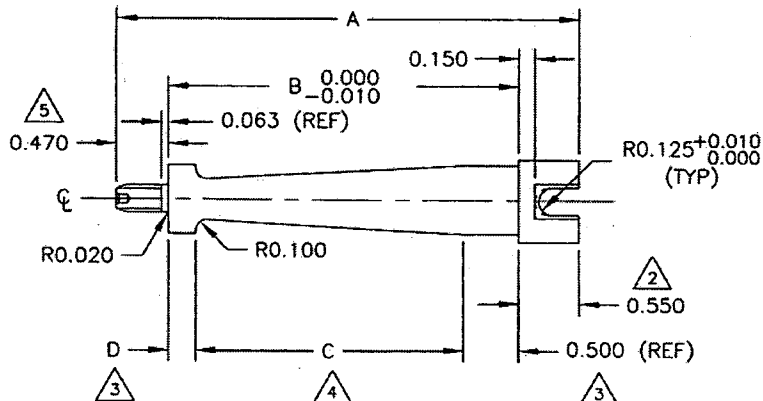
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

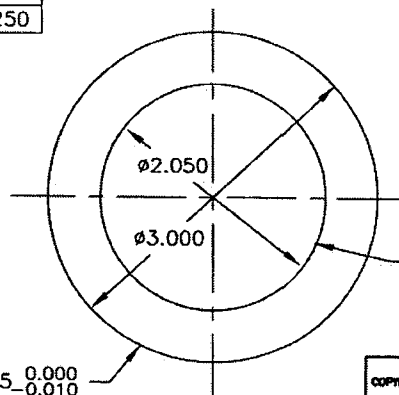
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

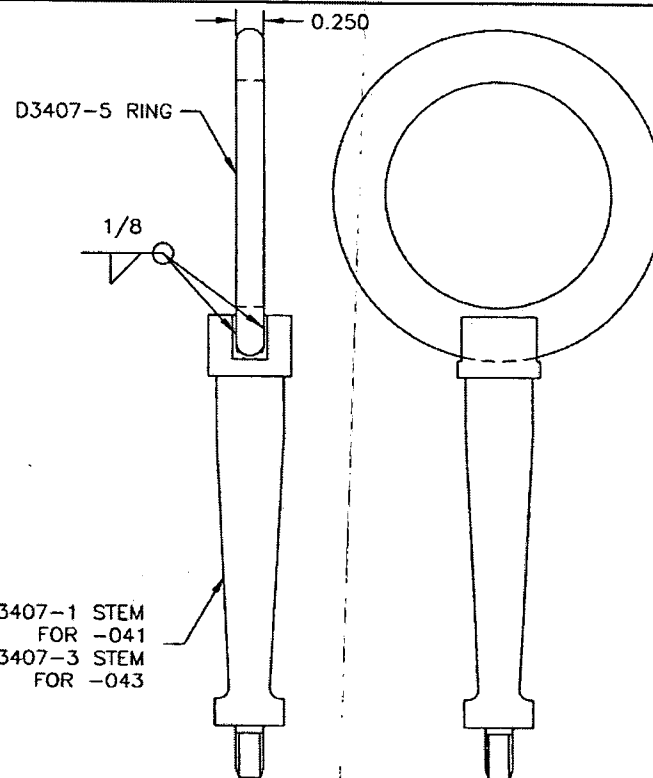
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3407-5 RING



USE D3407-1 STEM FOR -041
USE D3407-3 STEM FOR -043

D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	#	APPROVED #
DATE	05.09.09	DRAWING NO. D3407
		TOW RING

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NO. 28333
WORK ORDER
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

**CERTIFICATE OF CONFORMITY****SOLD TO:**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	DSK101	Support as per Dwg DSK101 D6103-003 B 28318	1987
20	DSK101	Support as per Dwg DSK101 D6103-003 B 28319	1987
40	D2968-5	Ring M4130NT3000W500 M102020 W/O 28267B	1987
20 22	D2968-5	Ring M4130NT3000W500 M102020 W/O 28268B	1987
20 22	D3407-5	Ring M174R3000 M18742 W/O 28333	1987

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shirley (Regula) Walz

36 06-09-20

VanKleek Hill September 20, 2006